

Date: Thursday, 11/06/2009 11:17:53 AM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	212 BASKET BASE ASS'Y RH
Job Number	48490B		Part Number	D3053042
Estimate Number	11543		Drawing Number	D3053 REV B
P.O. Number			Project Number	
This Issue	11/06/2009	S.O. No. :	Drawing Revision	B
Prsht Rev.	NC		Material	
First Issue	/ /	Type : LARGE FAB ASSY	Due Date	17/06/2009
Previous Run	47573B		Qty:	1
Written By			Um:	Each
Checked & Approved By	<u>Julie Dawson</u>			
Comment	Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF Est Rev:D 08-08-29 revB as per dwg DD verified by:EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
<b>Comment:</b> Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s) 304 SQ Tube.75x.75x.065W			
		1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.	Batch: <u>291123885</u>
2-Drill holes in D3053-3 as per dwg D3053			
2.0	D31661	Basket Hoop	
<b>Comment:</b> Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s) Basket Hoop <u>48491-1</u> Qty. 5 D3166-1 Batch: <u>B48425 -&gt; 4</u> <u>Cal 09.06.11</u>			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
<b>Comment:</b> LARGE FABRICATION RESOURCE 1			
		1-Cut 5 D2235-3 FROM D3166-1 using DT8365 <u>Op Log. 06.11</u>	
2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995 <u>Op Log. 06.11</u>			

4.0	D23273	Spacer Bushing	
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing Pick: Qty Part Number Description Batch			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:17:53 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 48490B

Part Number: D3053042

Job Number:



Seq. #: Machine Or Operation:

Description :

2 D2327-3 Bushing ✓ 344274 Cpl09.06.11

5.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

✓ Qty Part Number Description Batch  
2 D2232-3 Hinge plate 346949 Cpl09.06.15

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

✓ Qty Part Number Description Batch  
2 D2581 Mounting Bracket 347264 Cpl09.06.15

✓ 7.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

✓ Qty Part Number Description Batch  
48sq.ft M304EX0.75-16F Expanded Metal 111956 San 09-06-12 ①

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

Cpl09.06.15

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

① 09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:17:53 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 48490B

Part Number: D3053042

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/06/16 (X)

11.0 POWDER COATING POWDER COATING



M111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1ST

2ND

START TIME: 8:00 AM

9:40 AM

OVEN TEMPERATURE: 400°F

400°F

FINISH TIME: 8:30 AM

9:40 AM

09/06/16 (X)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/06/16 (X)

09/06/16 (X)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48490

q6617

(X)

14.0 QC21 FINAL INSPECTION/W/O RELEASE



09/06/16 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

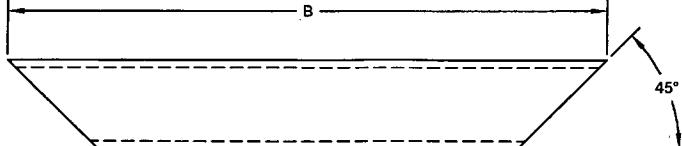
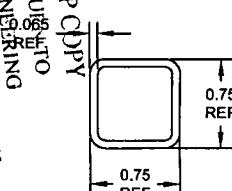
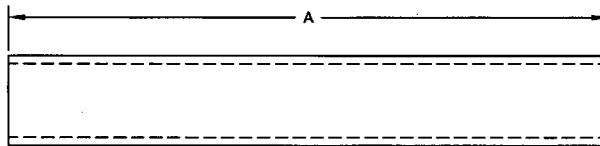
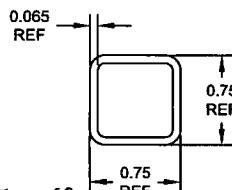
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

## PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



NO. 1858  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
REF. DART SPEC M304TS0.750W.065

**NOTES:**

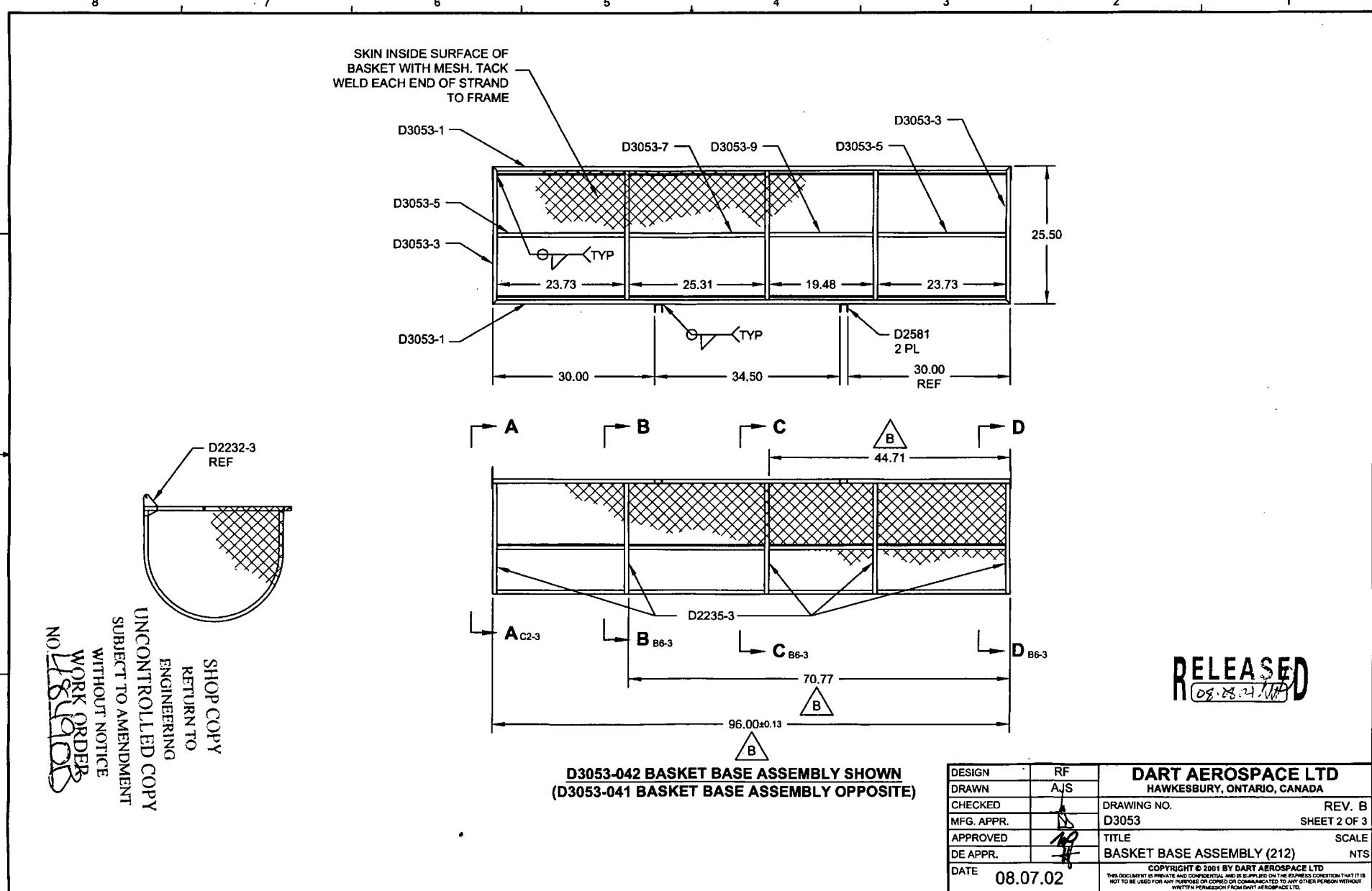
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

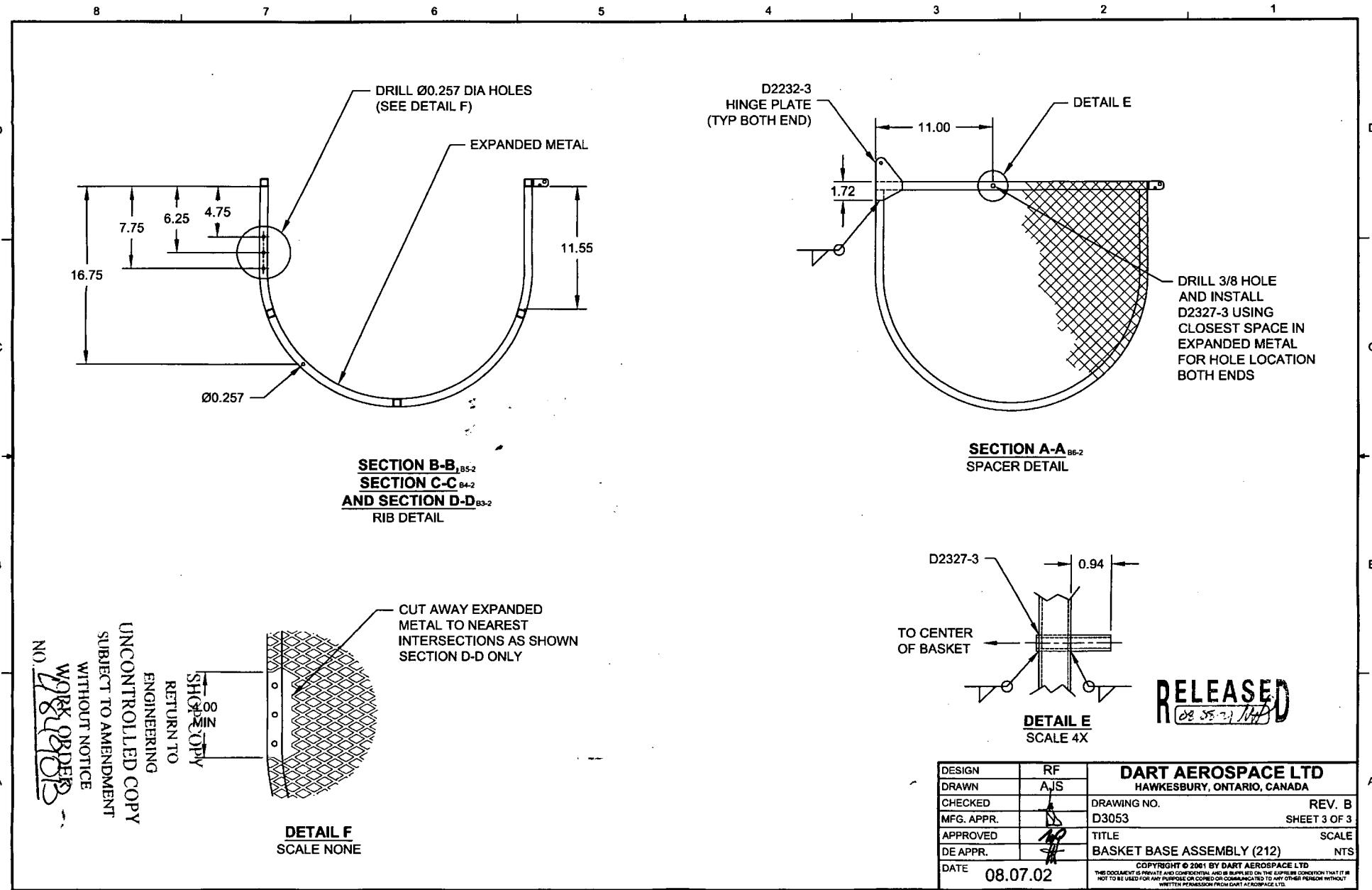
RELEASED  
09-08-2011

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.		
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO.	D3053
APPROVED		SHEET 1 OF 3	
DE APPR.		TITLE	BASKET BASE ASSEMBLY (212)
DATE	08.07.02	SCALE	NTS

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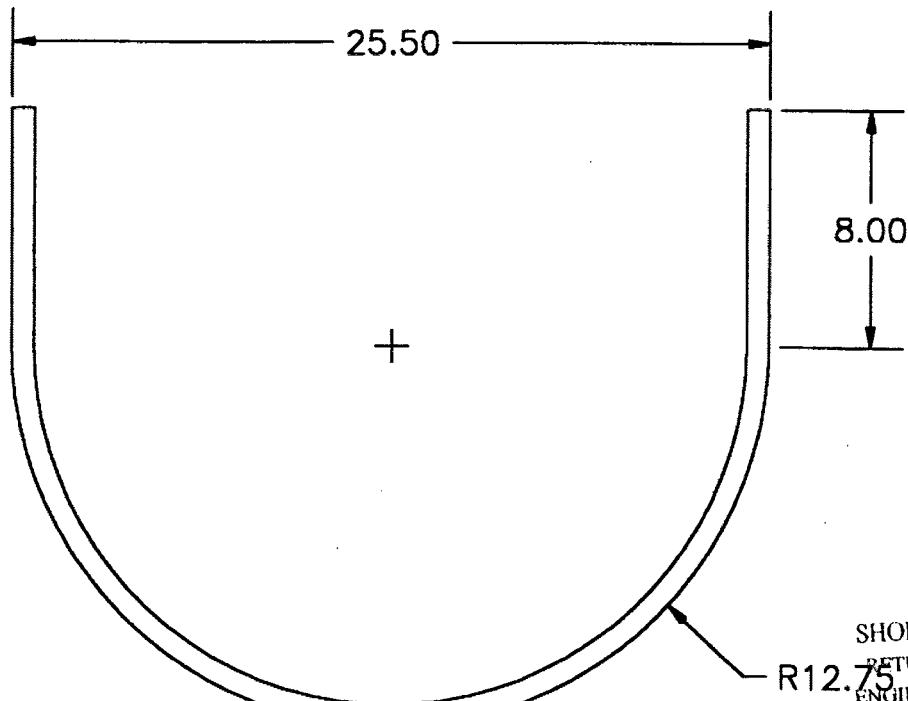
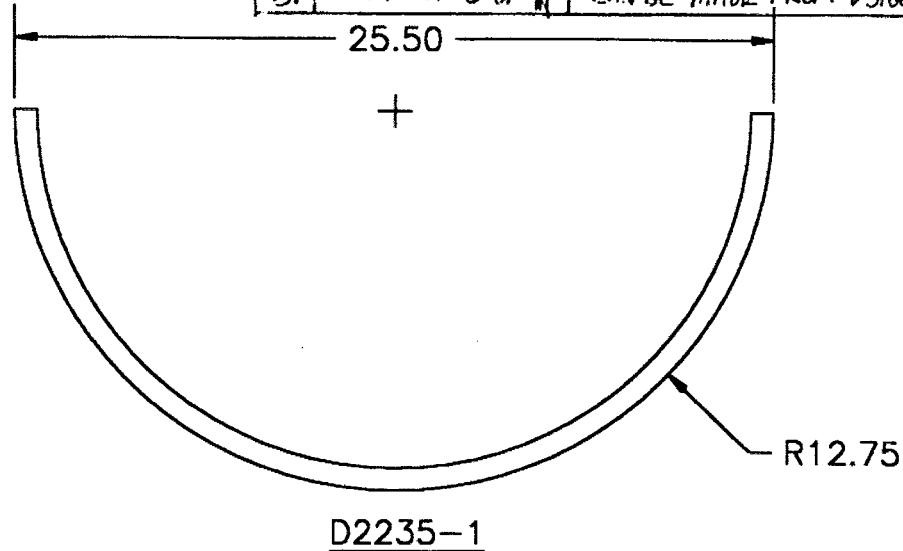
8 7 6 5 4 3 2 1





**DART**

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

B1 02.08.06 *BP* CAN BE MADE FROM D3166-1**RELEASED**  
16/03/07CAN BE MADE FROM D3166-1 *BP*MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL *HS4940B* SQR.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER